

Date: Tuesday, 09/09/2008 2:16:22 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MID TUBE ASSEMBLY
Job Number	: 41750		
Estimate Number	: 10469		
P.O. Number	:	Part Number	: D3391023
This Issue	: 09/09/2008 S.O. No. :	Drawing Number	: D3391 REV G
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SKIDTUBES	Drawing Revision	: G
Previous Run	: 41749	Material	:
Written By	:	Due Date	: 20/09/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JUD 08.9.09</u>		
Comment	: Est. A 05.10.20 New Issue KJ/EC Est. B 06.02.10 ECN773 dwg rev.D EC est C 07.03.20 rev F dwg EC est D 07.03.28 re-format EC est E 07.10.31 ecn 1053P EC Est Rev:F ECN 1056 07-11-13 DD verified by: EC Est Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25001100	Skidtube Extrusion
-----	-----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description
1	D2500-1-100	Extrusion

Batch

B37065

JUD

8-9-11

2.0	D3391021	Fwd Tube Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwd Tube Assembly

Batch: 541840

D

M 8-10-22

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

JUD 8-9-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MID TUBE ASSEMBLY

Job Number: 41750

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

- 5-Remove .030" from Fwd indexing Ridge as per Dwg D3391
- 6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391
- 7-Deburr
- 8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,
- 9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"
- 10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391
- 11-Open .375" holes to .438" ***do not open fwd saddle holes***
- 12-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)
- 13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021
- 14- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.
- 15- Locating from two fwd wearplate holes drilol remaining 6 wearplte holes in D3391-021 using DT8937
- 16- Open 2 fwd wearplate holes in D3391-023 to .250" dia.
- 17- Open 12 wearplate holes in D3391-021 to 0.297" dia.
- 18-Deburr and blow out all chips from inside tube

JP8-9-11

M
21022

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

800/6/22 (10)

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AHM 9-10.3)

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: MID TUBE ASSEMBLY

Job Number: 41750

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

① M 8-12-23

7.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Pick:

Qty Part Number Description

1 D3389-1 Web

A/R Sikaflex-241/-291

Sikaflex expire date:

Batch B41833
B53894
M109449
8-10-01

① M 8-12-23

Start: 8-12-23 Time: 1:30

Finish: 8/10/24 Time: 7:15 AM

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open float bag holes as per dwg

2-C'sink float bag holes as per dwg

3- Prepare tube for welding

4-Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

M 8-12-23

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/10/24

10.0

D36811

Spacer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

SPACER

batch:

B 41248

M 8-12-24 ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 41750

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Weld crossbolt spacer as per dwg D3391 & QSI 004

AIR M109213

BK 08/10/27

12.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S

08/10/28

(X)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S

08/10/28

(X)

14.0

POWDER COATING

POWDER COATING



M 109152



(X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:50
322 OF
1:20

M-L 08/10/30

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-02

(X)

16.0

D35911

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bushing

B 41140

DP/FL

8-11-3

17.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: SKIDTUBESS RESOURCE 1

1- insert D3391-021 into D3391-23

2- insert T-pins into first and third fwd saddle holes

3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DSI 9364

4- remove T-pins and locate DT9415 from first and third crossbolt hole using T-pins and clekos

5- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". Remove DT9415

DP
FL
8-11-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: MID TUBE ASSEMBLY

Job Number: 41750

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

6- deburr, re-alodine and blow out chips

7- press fit D3591-1 spacers using DT9416 starting from 0.500" side

Handwritten: > DP / FL 8-11-3

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 8-08/11/05

19.0

ALS41032130

Insert



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

INSERT

batch: M105819

or equivalent

per QSI 017

Handwritten: JH

20.0

ALS41032225

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

INSERT

batch:

or equivalent

per QSI 017

Handwritten: n/a 8-08/11/05

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

Handwritten: JH 08-11-05

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 8-08/11/05

23.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty

1

Part Number

D3401-041

Description

Tow Cap

Batch

Handwritten: n/a 8-08/11/05
not installed on mid tube

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: MID TUBE ASSEMBLY

Job Number: 41750

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description:

24.0

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE

25.0

D356613

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET

26.0

D36721

Phenolic Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
PHENOLIC WASHER

27.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty

4

Part Number

AN3C4A

Description

Bolt

Batch

Parts not installed on MIP tabs.

28.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
washer

29.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Install tow Cap as per Dwg D3391
Identify as D3391-021

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inspect thread of each insert using DT8821

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: MID TUBE ASSEMBLY

Job Number: 41750

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPD 91487 *Le 8/4/7* *(1)*

32.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/10 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-07

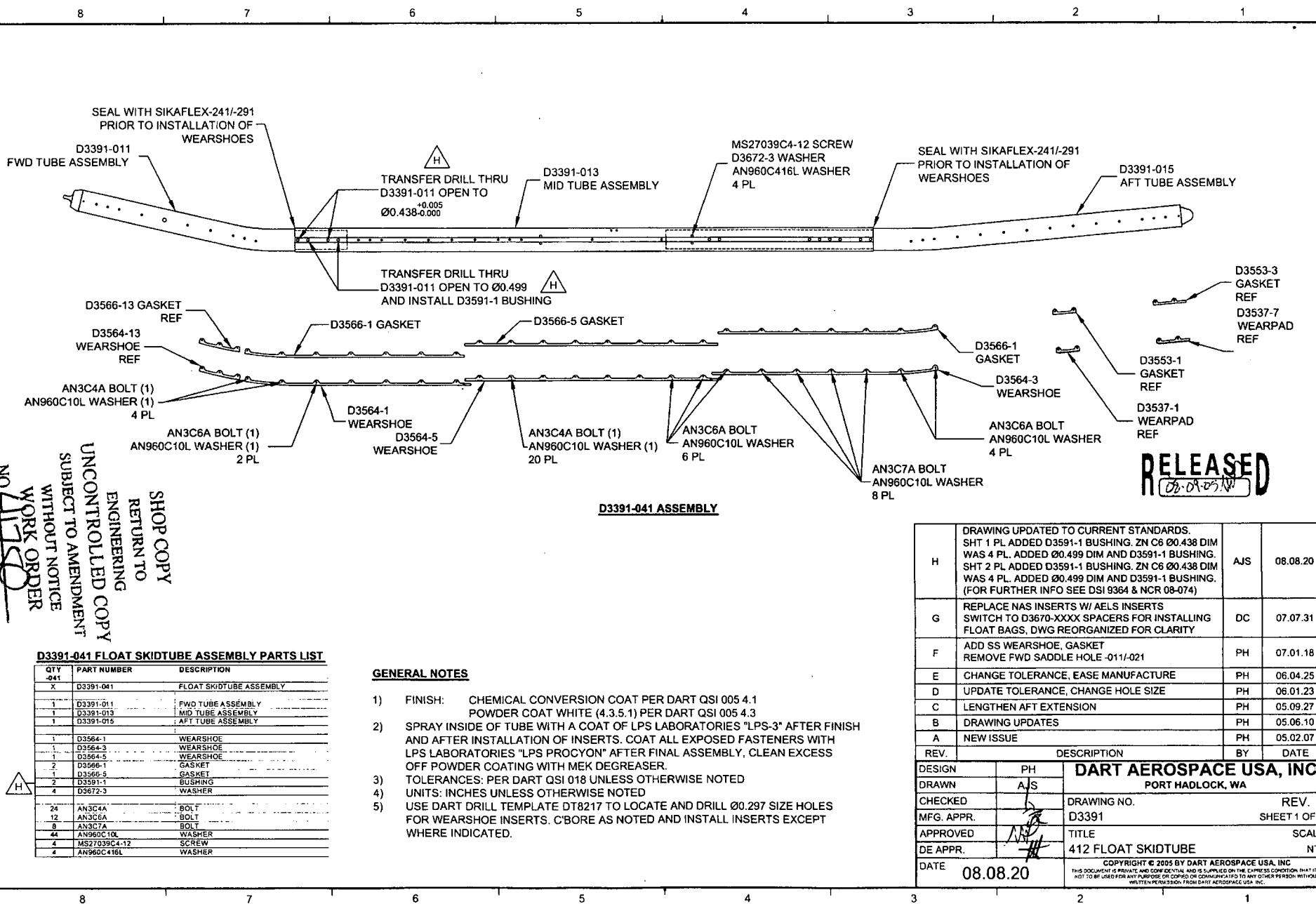
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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NO 41750

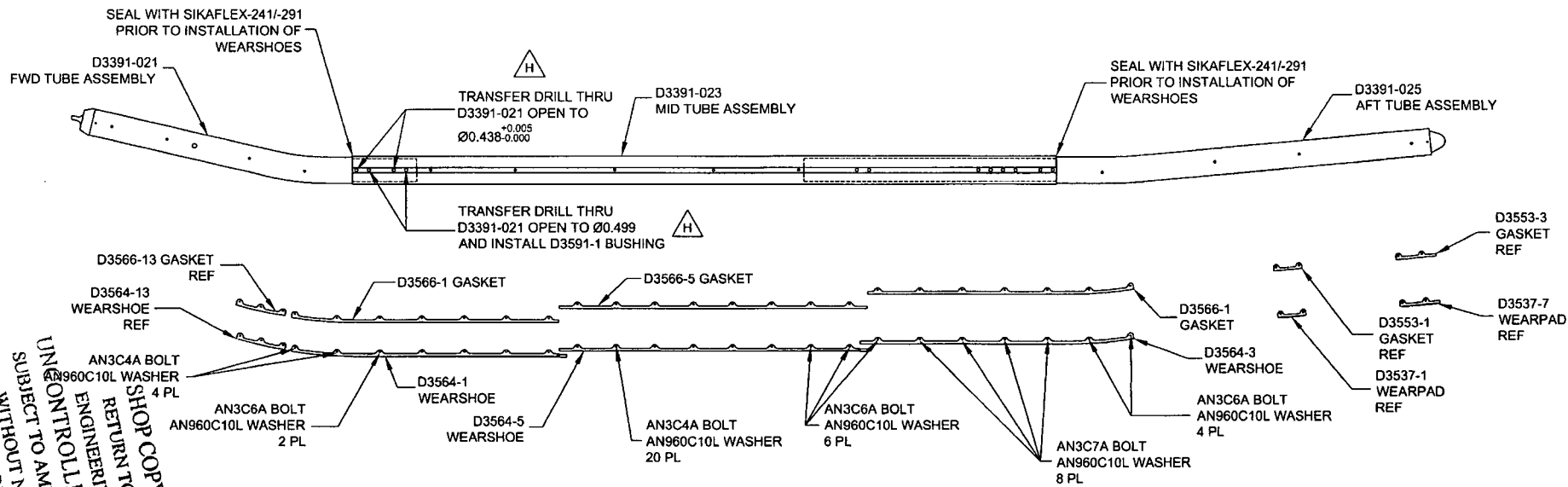
D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL. ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL. ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
2	D3566-5	GASKET
2	D3566-13	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

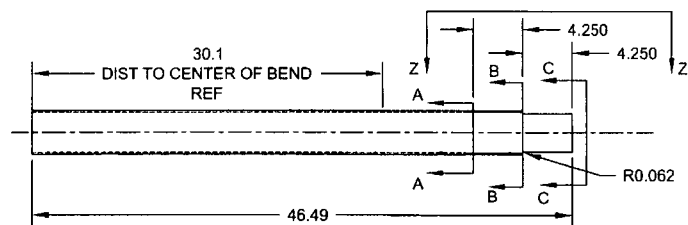
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

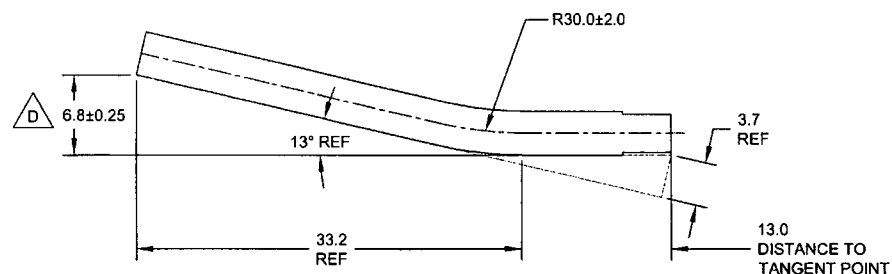
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08-09-25/14

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
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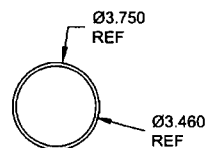
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WORK ORDER
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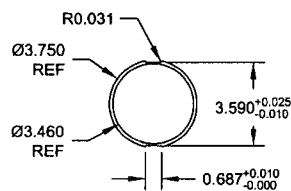
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



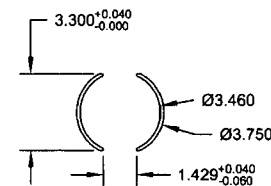
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



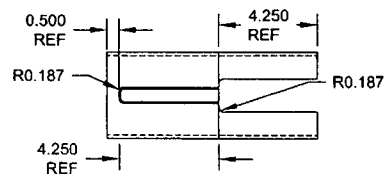
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

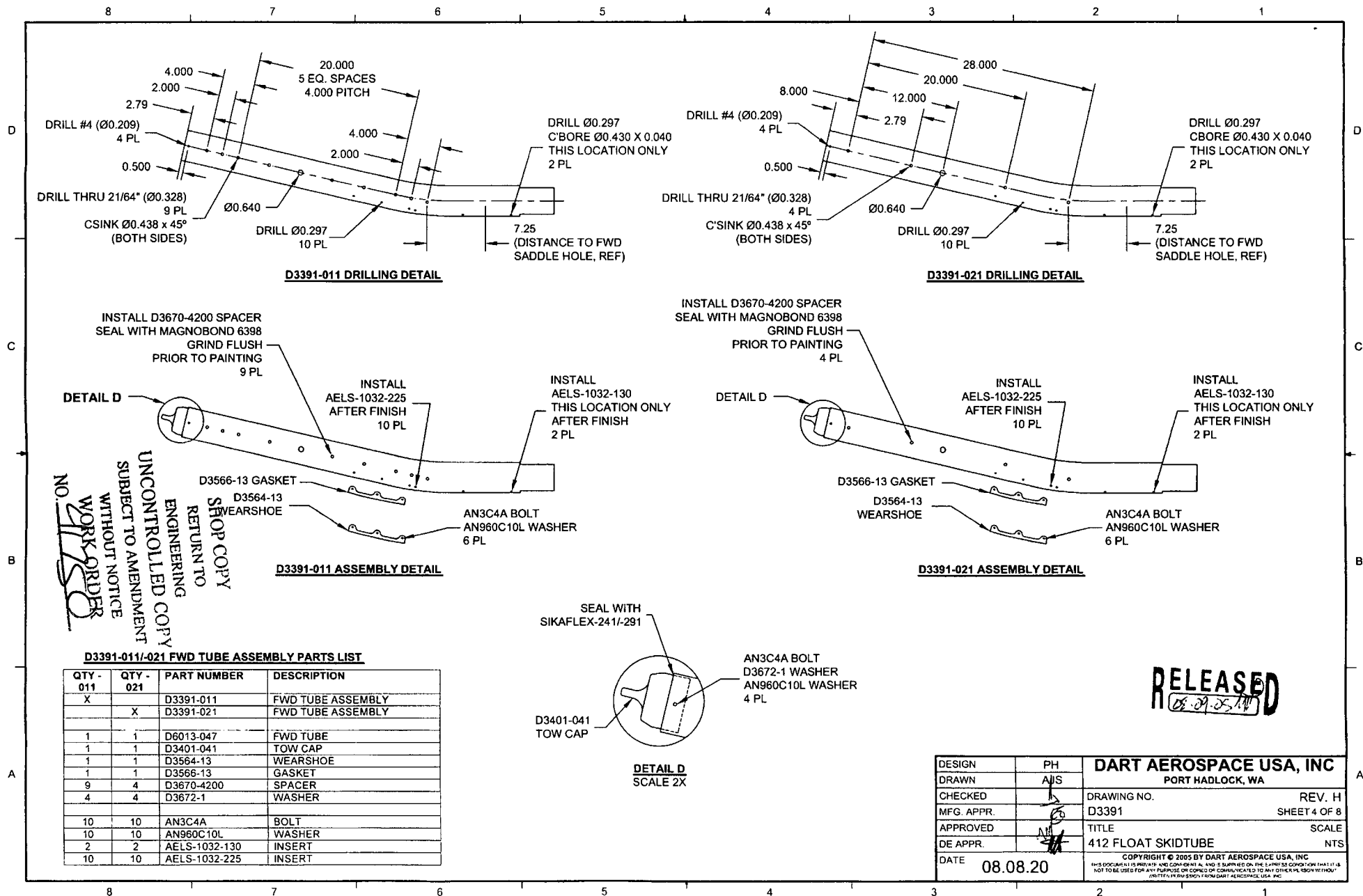


VIEW Z-Z
SCALE 2X

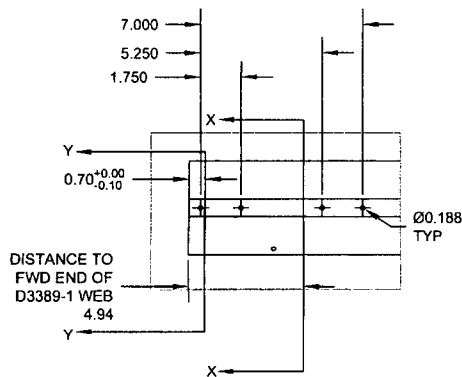
RELEASED
8-8-05

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
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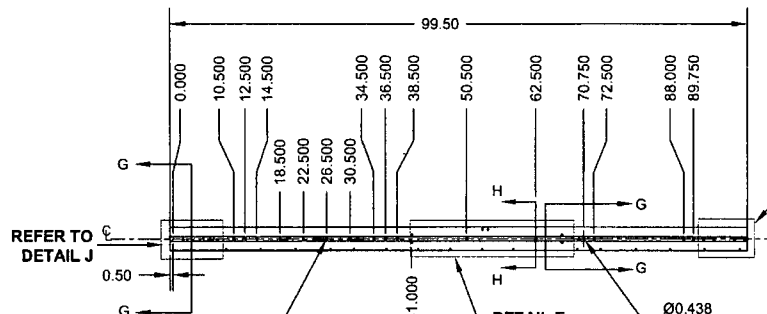


8 7 6 5 4 3 2 1

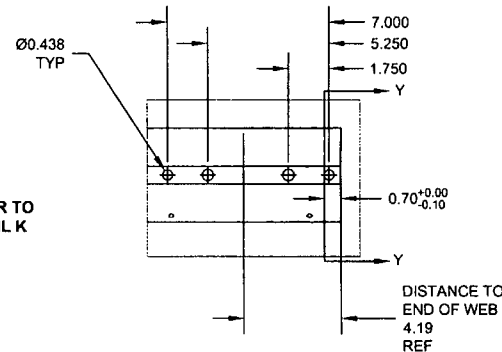


DETAIL J
SCALE 4X

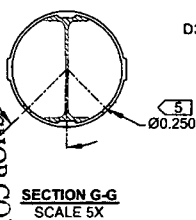
DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



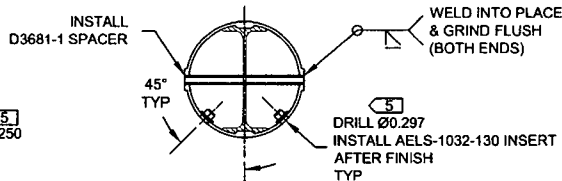
D3391-013 ASSEMBLY DETAIL



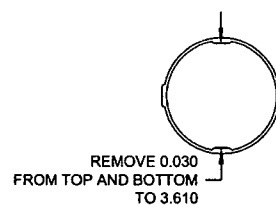
DETAIL K
SCALE 4X



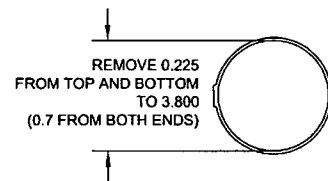
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X

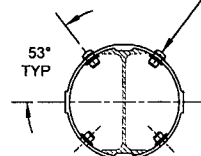


SECTION X-X
SCALE 5X

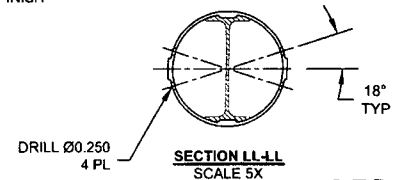


SECTION Y-Y
SCALE 5X

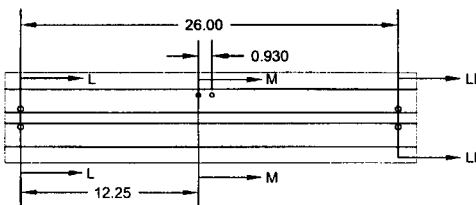
DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



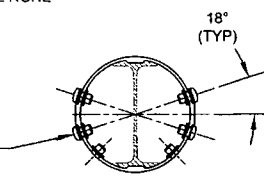
SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X



DETAIL E
SCALE NONE



SECTION L-L
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

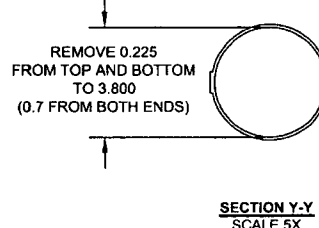
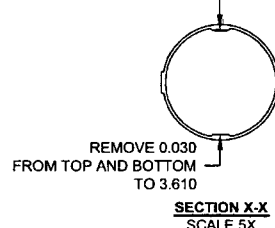
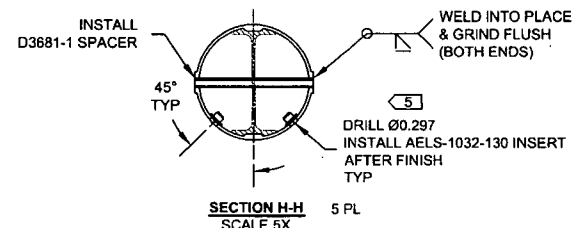
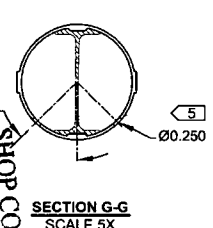
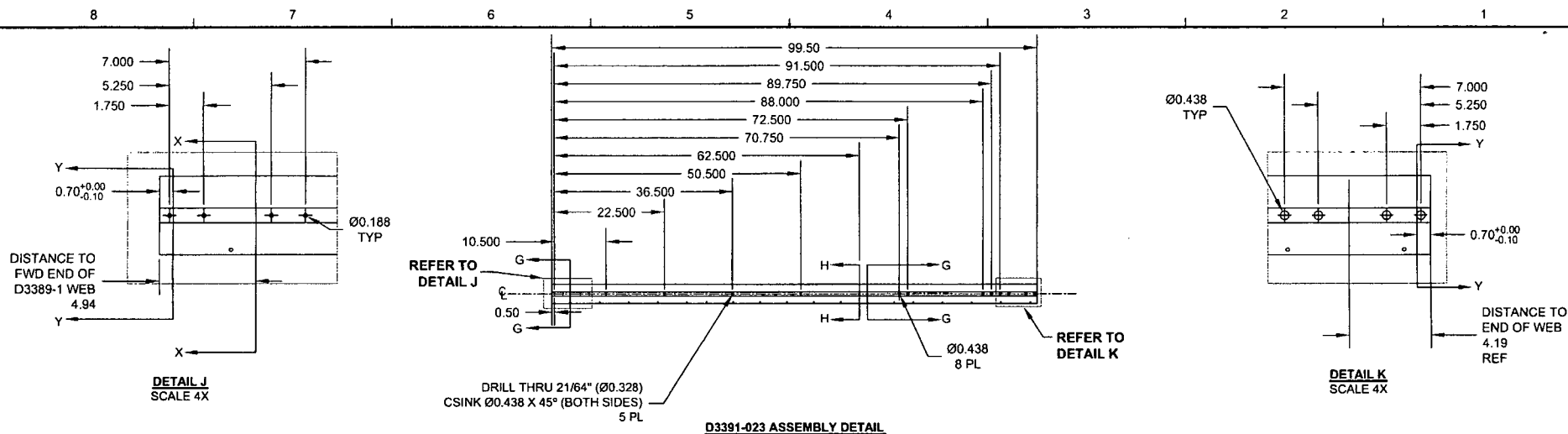
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D3391-023 MID TUBE ASSEMBLY PARTS LIST

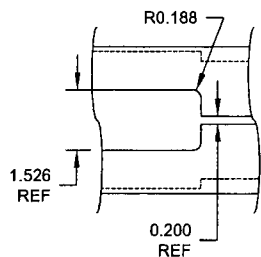
QTY	PART NUMBER	DESCRIPTION
1	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

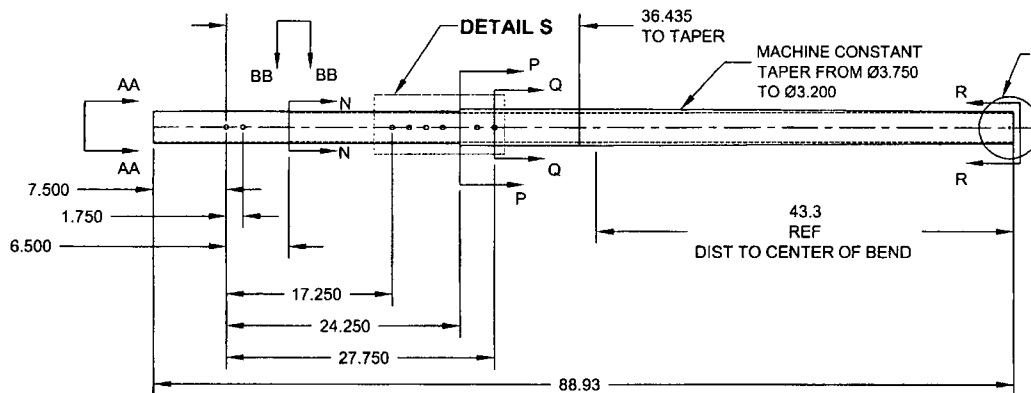
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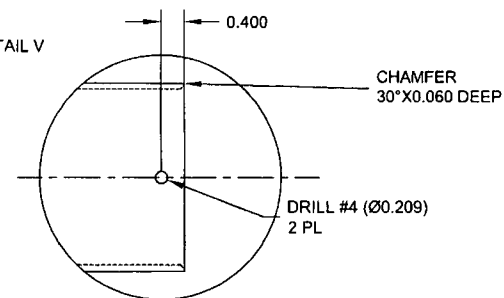
8 7 6 5 4 3 2 1



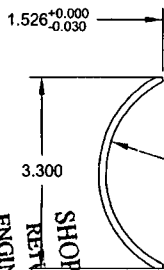
VIEW BB-BB
SCALE 4X



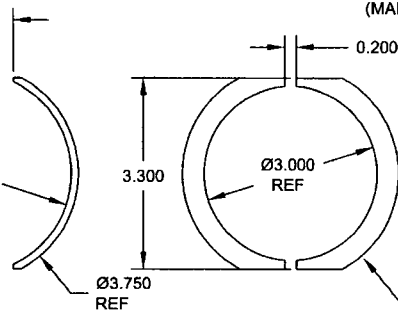
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



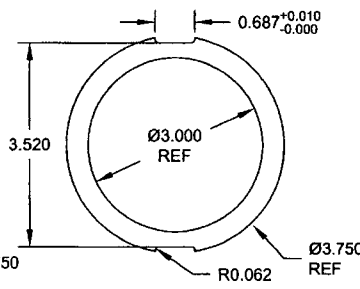
DETAIL V
SCALE 6X



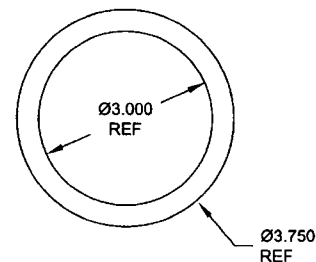
SECTION AA-AA
SCALE 6X



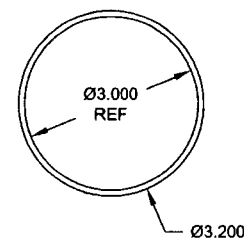
SECTION N-N
SCALE 6X



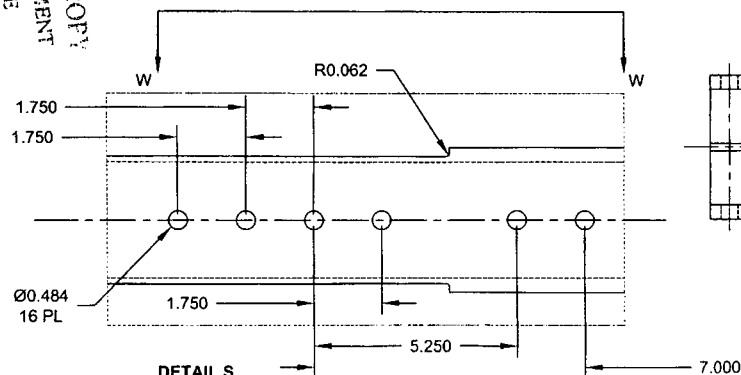
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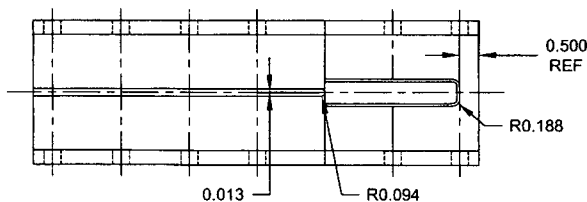
SECTION Q-Q
SCALE 6X



SECTION R-R
SCALE 6X







DETAIL S
SCALE 4X

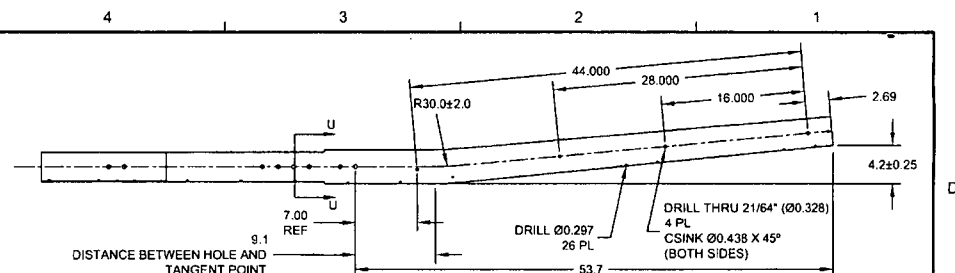


VIEW W-W
SCALE 4X

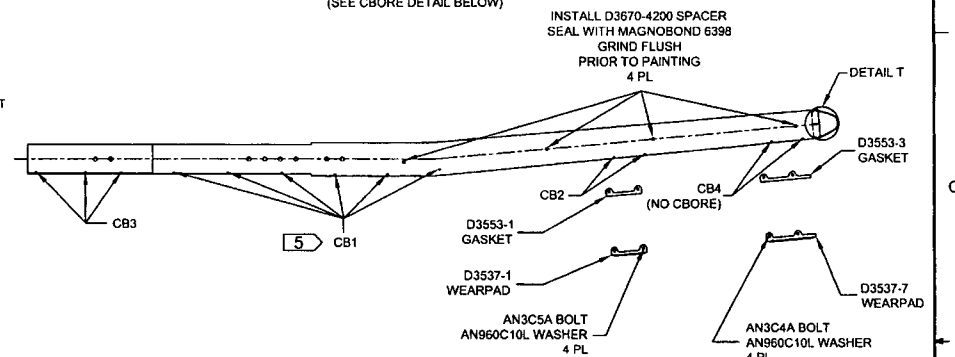
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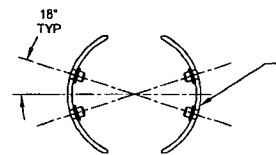


D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

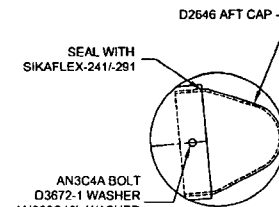


D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



SECTION CC-CC
SCALE 3X







DETAIL T
SCALE 4X

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08-09-25 144

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AFI S-1032-130

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NO. 174

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 41748
Part number: D339 1023
Description: Mid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]

Penetration:

pass[☒] fail[]

UNACCEPTABLE

Cracks:

pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

pass[☒] fail[]

Coloration:

pass[☒] fail[]

Qualifier Pat. Dunal Date of Test Coupon 080924

Welder Barclay Elliott Date of Test Coupon 08-09-24

The above named individual is qualified in accordance with AWS D17.1.2001 to weld